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D350-636-024
Job Sheet 193533



Part No: D350-636-024

Job Qty: 1 ea

Part Name: AS350/355 - Skidtubes - Standard w/ Heavy-Duty Wearplates - RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/16/19

Job Tracking No:

Due Date: 4/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D4168-052 REV.C, IIN-D350-636 REV.K IPP REV.A 18.11.29 NEW ISSUE DD VERF.:JFS

Ship Via:

Bill of Materials

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/30/19	0.00	0.00	Start Up Skid tubes-1		
110	Skid tubes	1 pcs		4/30/19	0.00	4.78	Skid tubes-1		HE
120	QC	1 pcs		4/30/19	0.00	0.00	QC10		HE
130	QC	1 pcs		4/30/19	0.00	0.00	QC5		CPL DAS
140	HandFinish	1 pcs		4/30/19	0.00	0.98	HandFinish1		MAY 01 2019
150	QC	1 pcs		4/30/19	0.00	0.00	QC7-2		D.R 19/05/2019
160	Skid tubes	1 pcs		4/30/19	0.00	4.78	Skid tubes-1		mcg
170	QC	1 pcs		4/30/19	0.00	0.00	QC10		HE
180	QC	1 pcs		4/30/19	0.00	0.00	QC5		CPL
190	HandFinish	1 pcs		4/30/19	0.00	0.98	HandFinish2		CPL
200	SprayPaint	1 pcs		4/30/19	0.00	0.61	Spray Paint		AS 19-6-16
205	Outsource	1 pcs		4/30/19			ATE003-VC	5	AS 19-6-16
210	QC	1 pcs		4/30/19	0.00	0.00	QC14		NR
230	HandFinish	1 pcs		4/30/19	0.00	0.98	HandFinish4		BEB 19-06-18
240	QC	1 pcs		4/30/19	0.00	0.00	QC5		W 19-6-16
250	Packaging	1 pcs		4/30/19	0.00	0.00	Packaging1-3		JUN 21 2019 68
260	QC	1 pcs		4/30/19	0.00	0.00	QC4		11/11 9-89
270	Packaging	1 pcs		4/30/19	0.00	0.00	Packaging3-1		SMBS
275	DC	1 pcs		4/30/19	0.00	0.00	DC		AUG 26 2019 DAS
280	QC21-FG	1 Ea		4/30/19	0.00	0.00	QC21		AUG 26 2019 70

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg

Descriptions: D4168-6 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168 (D4168-6 details). Drill using drill Jlg DT8150 & DT8863A for first side only DT8863B for second side 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section DK-DK and open to 0.500" 5- Drill tow ring hole using DT9616 detail "DF" 6- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole 7- Open up holes of Detail DF to 0.297" (total of 2 holes per side) +.201" (total of one hole per side DT9616) as per dwg D4168. 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 138989 9- Grind welds flush as per Dwg D4168

160 - 1-Open up holes using hole saw of Detail DG and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168. 4-Chamfer holes of Detail DG, ground handling and float holes per dwg D4168 (welding instructions on sheet) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5163437 exp. date: 2/12/19 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D2743 as per dwg D4168 & QSI004 (welding instructions on sheet) A/R Aluminum Rod batch: 139011 10-Grind welds flush as per Dwg D4168 11-Spot face ground handling holes section ES-ES (total of 4 places per side) as per dwg D4168 12- C'bore section ET-ET. ADJUST TOOLING AS REQUIRED. VERF BY: 13- Deburr holes, ensure tube is free of all scratches before sending to paint. ***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE *****

*****REF TO W/O BATCH:

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5189640 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5188693

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-4, wearshoes and ground handling hardware as per dwg D4168 SIKAFLEX 241 BATCH: 5163437 EXP DATE: 12-12-19 5- Coat all exposed fasteners with "LPS Procyon" batch: 11133690

250 - If making a D350-636-216 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A

260 - *****ensure antiseize is on AN8C21A bolts*****

270 - Identify and pack for shipping as per PPPD350-636-024 Location : FG071

275 - record fwd angle: 89.8 Photocopy blue file and type labels per PPP D350-636-024 CHG 001

DAS
59
9-89

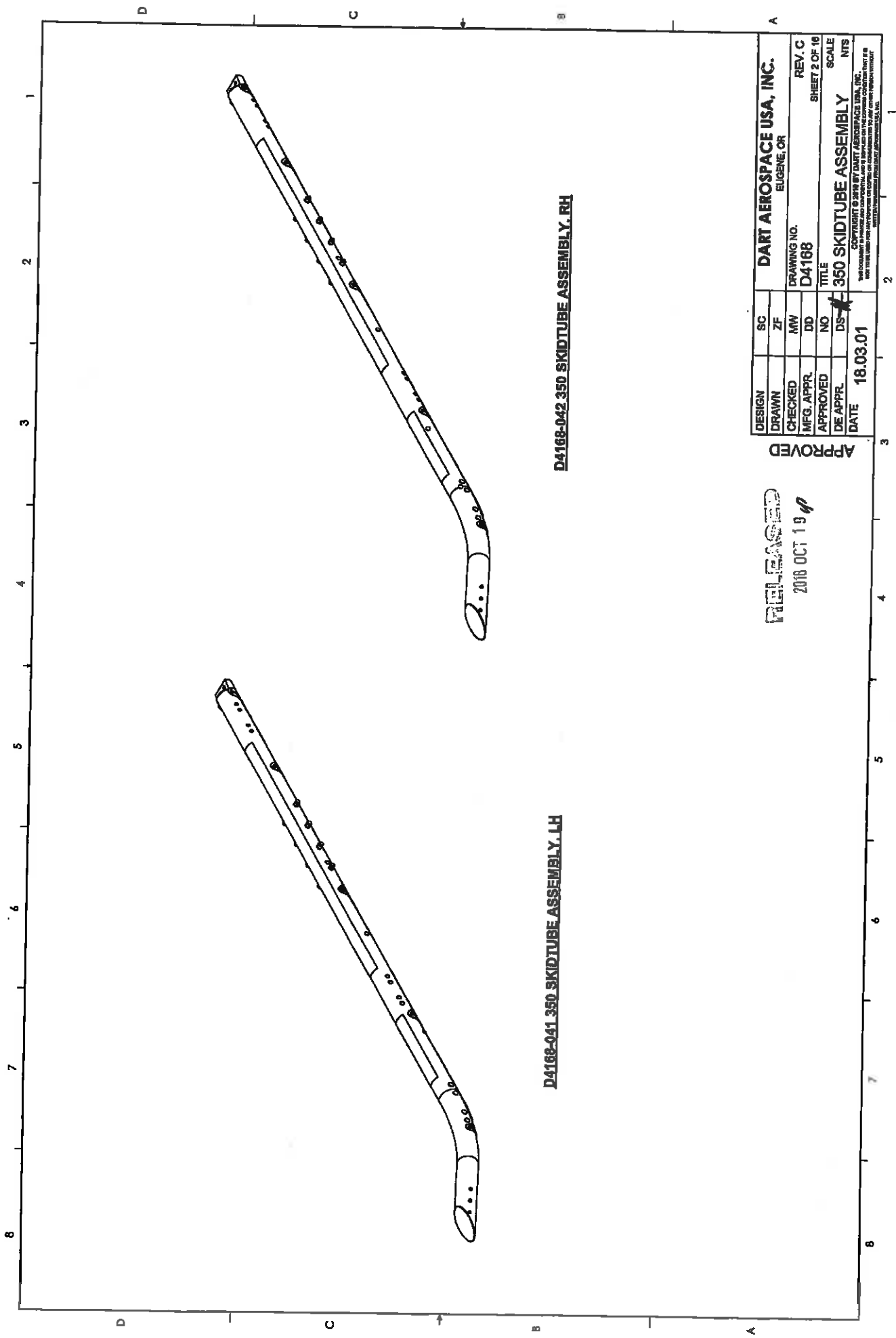
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 pcs (1 ea)	90-Start up Operation	M.H. 010451
D2744	Cap	1 pcs (1 ea)	90-Start up Operation	5166246
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes	5153407
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes	5156521 x 7 5182366 x1
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-HandFinish	5167517
AN3C34A	Bolt	1 Ea (1 ea)	230-HandFinish	5186091-1
AN3C36A	Bolt	4 Ea (4 ea)	230-HandFinish	F-1137074-1-2
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5174235
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	5176396
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	5167090
D2745	Bushing	8 pcs (8 ea)	230-HandFinish	518584
D3488-4	Blade Fitting, RH	1 pcs (1 ea)	230-HandFinish	5180162
D3631-1	Washer	8 pcs (8 ea)	230-HandFinish	5184192
D3873-1	Bushing	7 pcs (7 ea)	230-HandFinish	5175778
D4154-041	Wearplate Assembly	1 pcs (1 ea)	230-HandFinish	5191509
D4170-1	Bushing	4 pcs (4 ea)	230-HandFinish	5137508 x 2 5175926 x 2
D4171-1	Bushing	1 pcs (1 ea)	230-HandFinish	5180790
MS21043-3	Nut	5 Ea (5 ea)	230-HandFinish	5099569
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5181777
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5167203-1
NAS1149C0332R	Washer	4 Ea (4 ea)	230-HandFinish	5158078
NAS1149C0363R	Washer	9 Ea (9 ea)	230-HandFinish	5135100
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	5076017-2
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5083559
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging	5194553
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	5160967
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging	5191663
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5184203
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	5166718

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-RH	1	6	0
160-Skidtubes	D2744	1	23	0
	D2739	1	10	0
	D2743	8	151	0
230-HandFinish	ALS4-1032-225	4	1,280	0
	AN3C34A	1	12	0
	AN3C36A	4	351	0
	AN3C6A	4	218	0
	AN6C44A	4	132	0
	AN8C35A	1	62	0
	D2745	8	168	0
	D3488-4	1	2	0
	D3631-1	8	213	0
	D3873-1	7	76	0
	D4154-041	1	0	0
	D4170-1	4	38	0
	D4171-1	1	8	0
	MS21043-3	5	1,090	0
	MS21043-6	4	158	0
	MS21083C8	1	332	0
	NAS1149C0332R	4	3,957	0
	NAS1149C0363R	9	493	0
	NAS1149C0832R	1	340	0
	NAS1515H3L	4	358	0
250-Packaging	AN3C37A	1	84	0
	AN8C21A	2	85	0
	D2741	1	63	0
	MS21083C8	2	332	0
	NAS1149D0863J	2	585	0

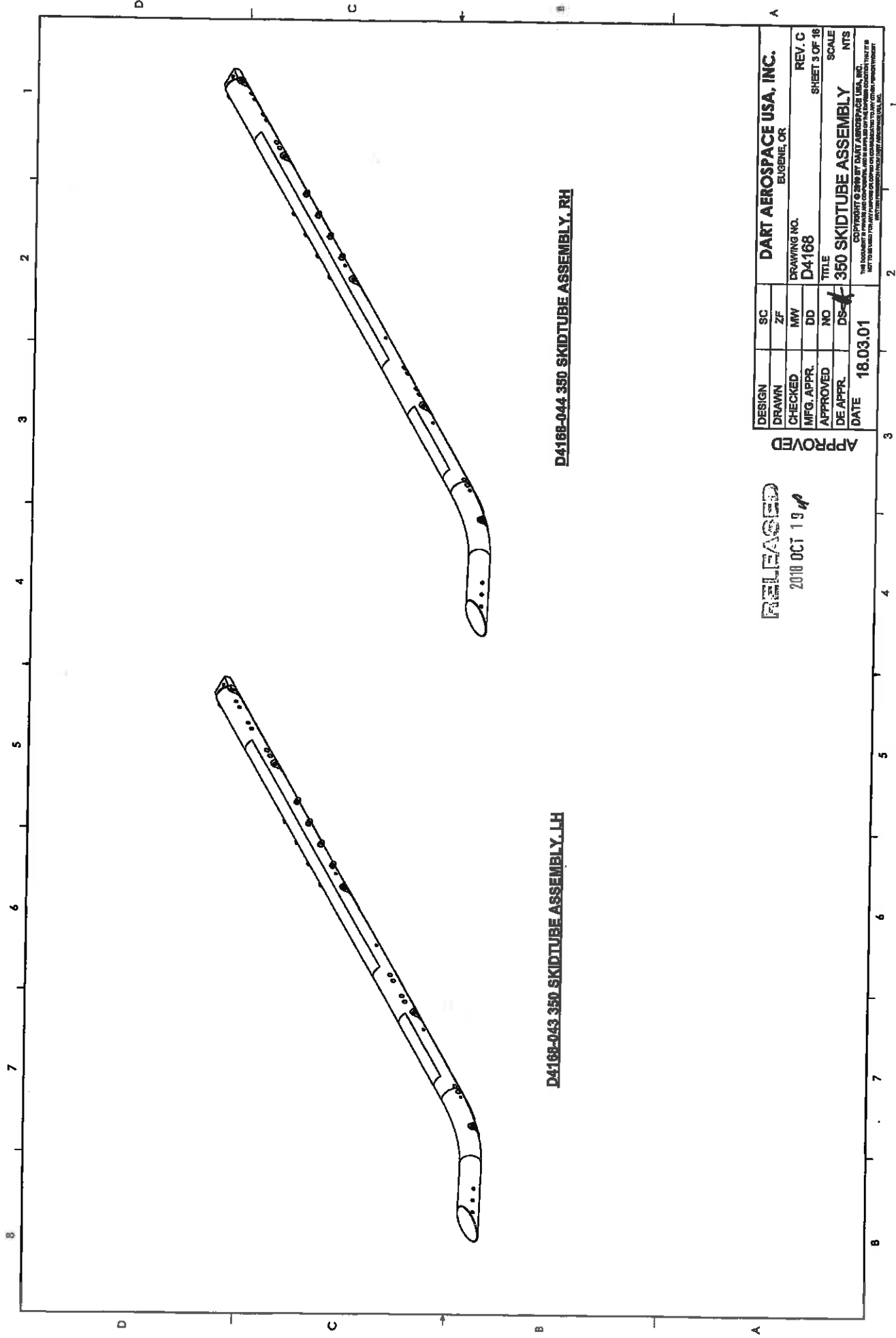
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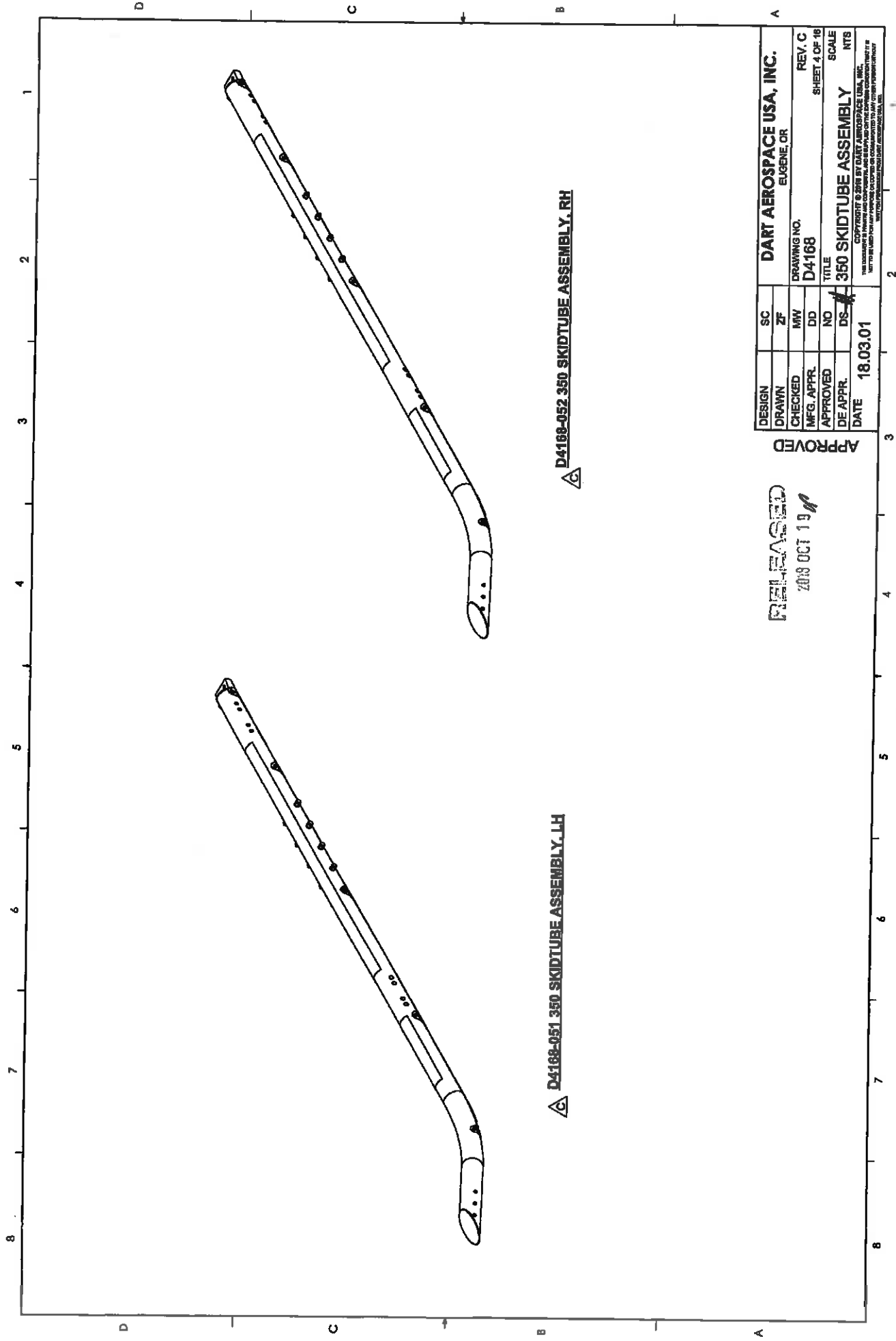
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2018 OCT 19





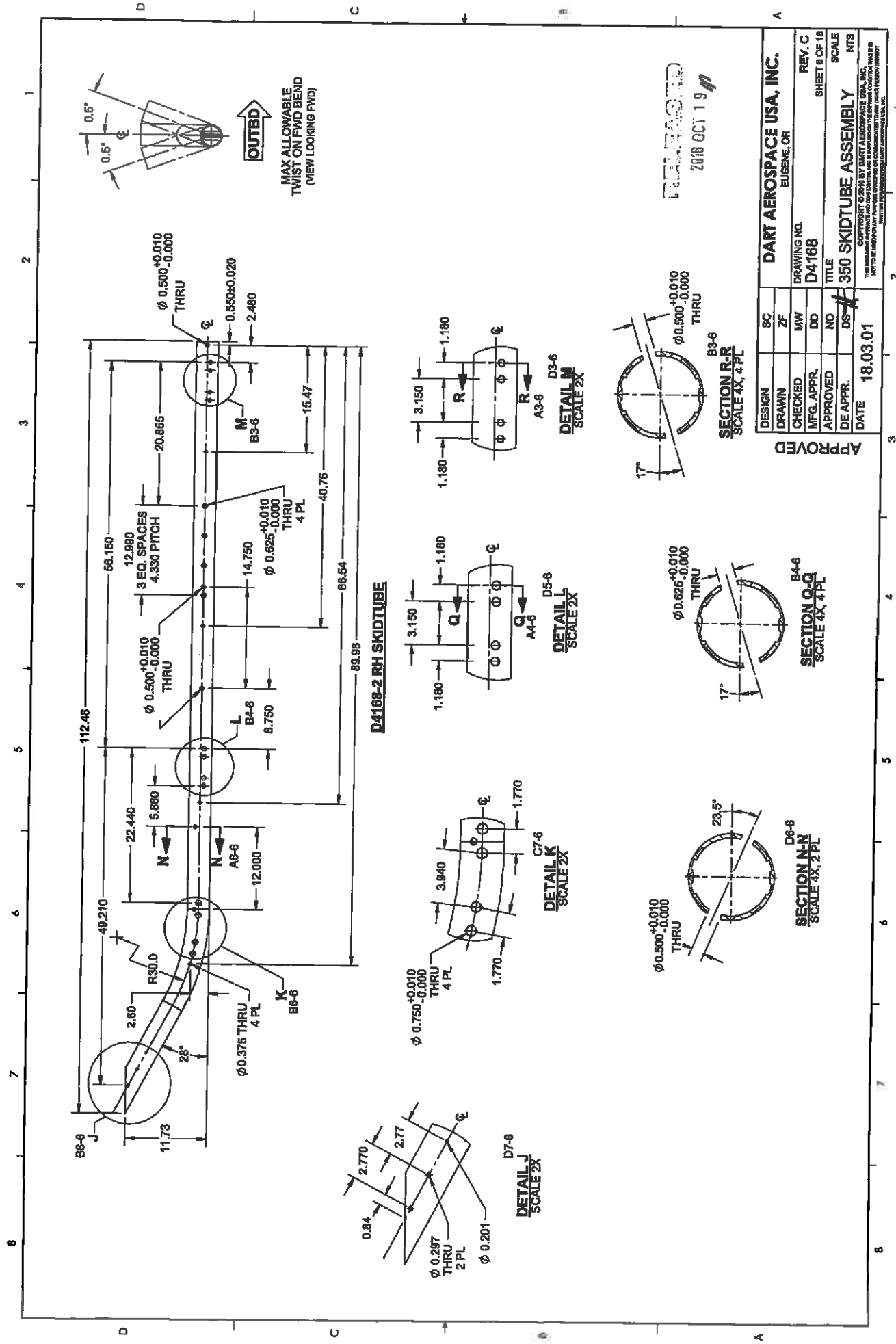
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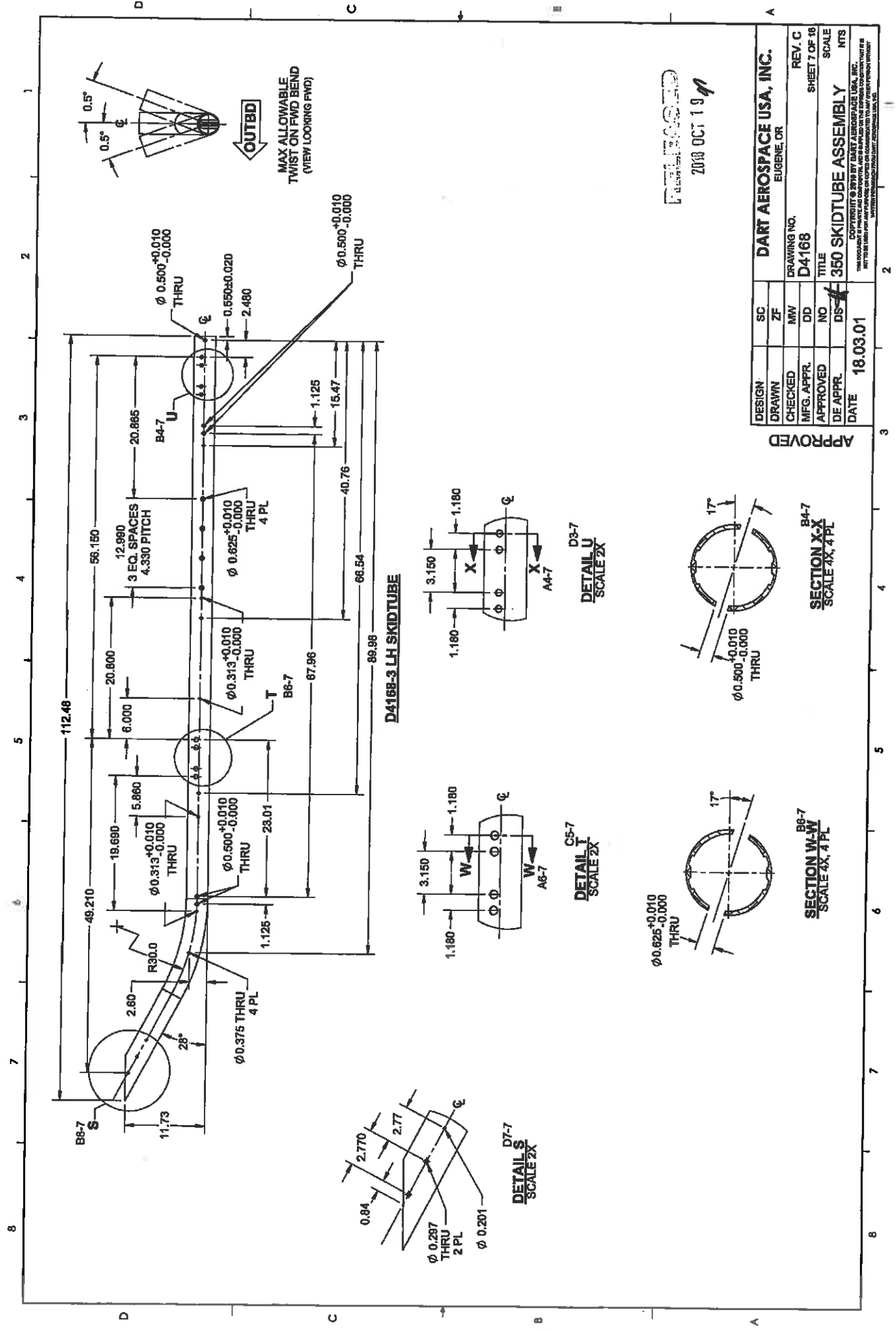
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APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01		

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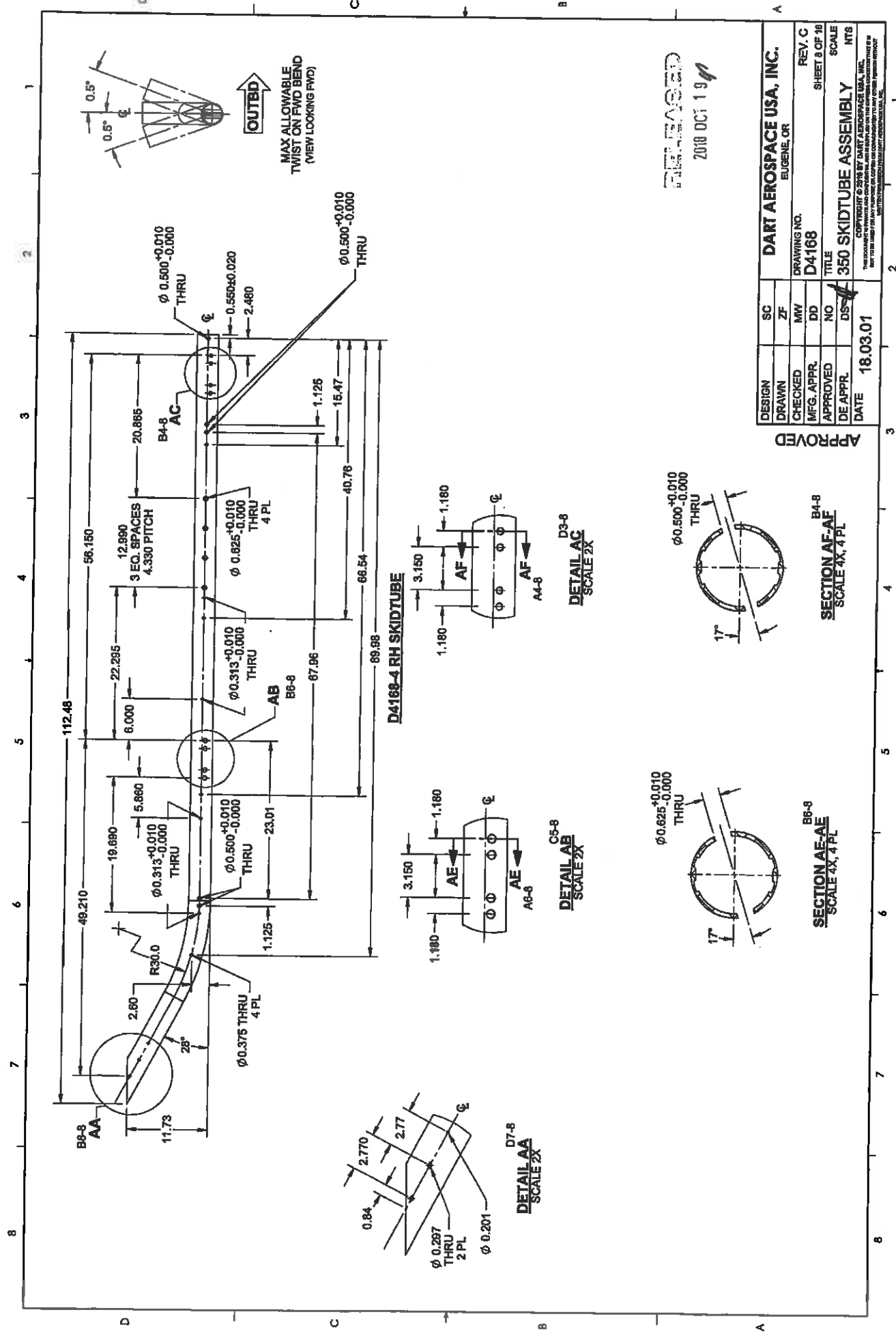


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				NTS			
APPROVED				REV. C			
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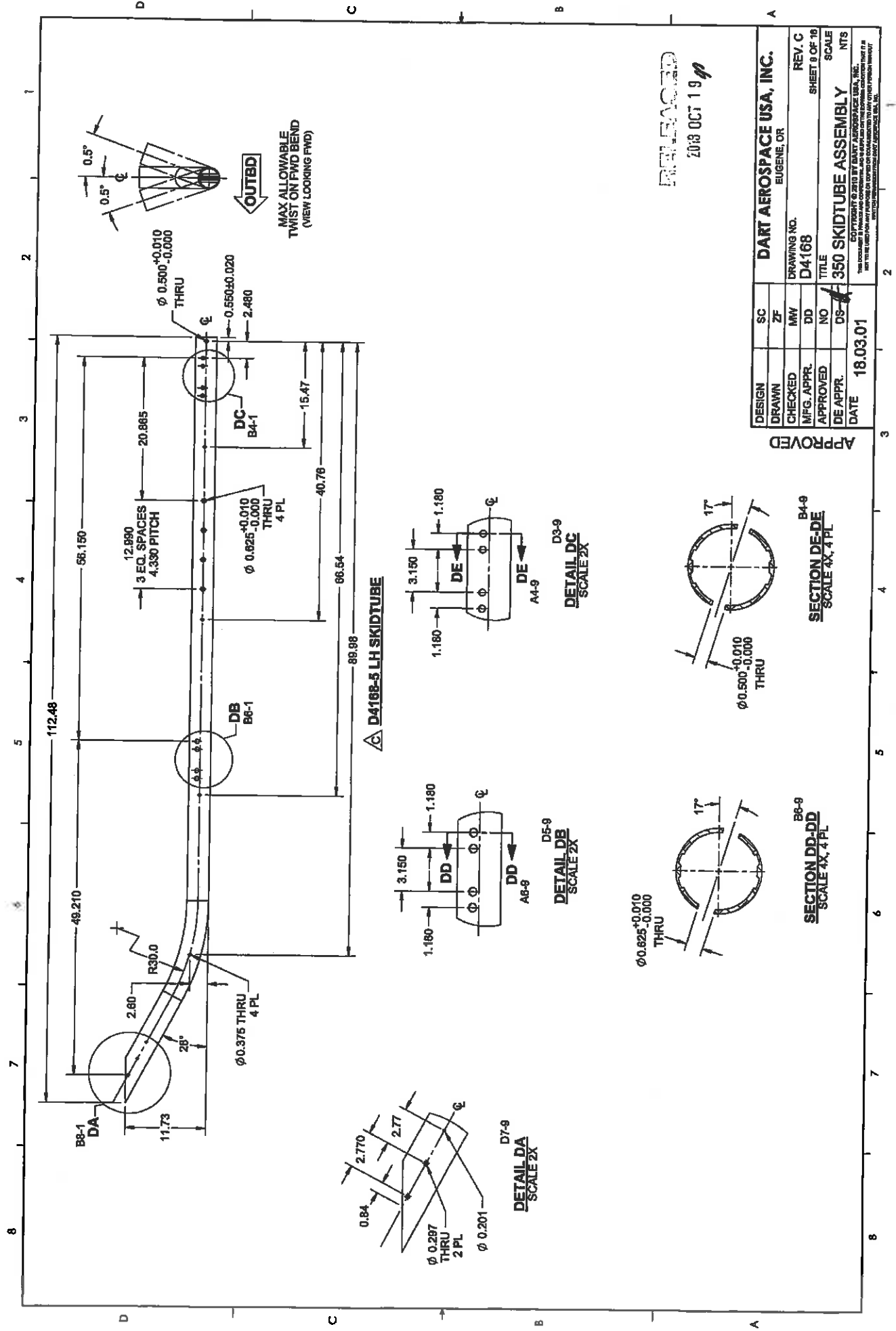


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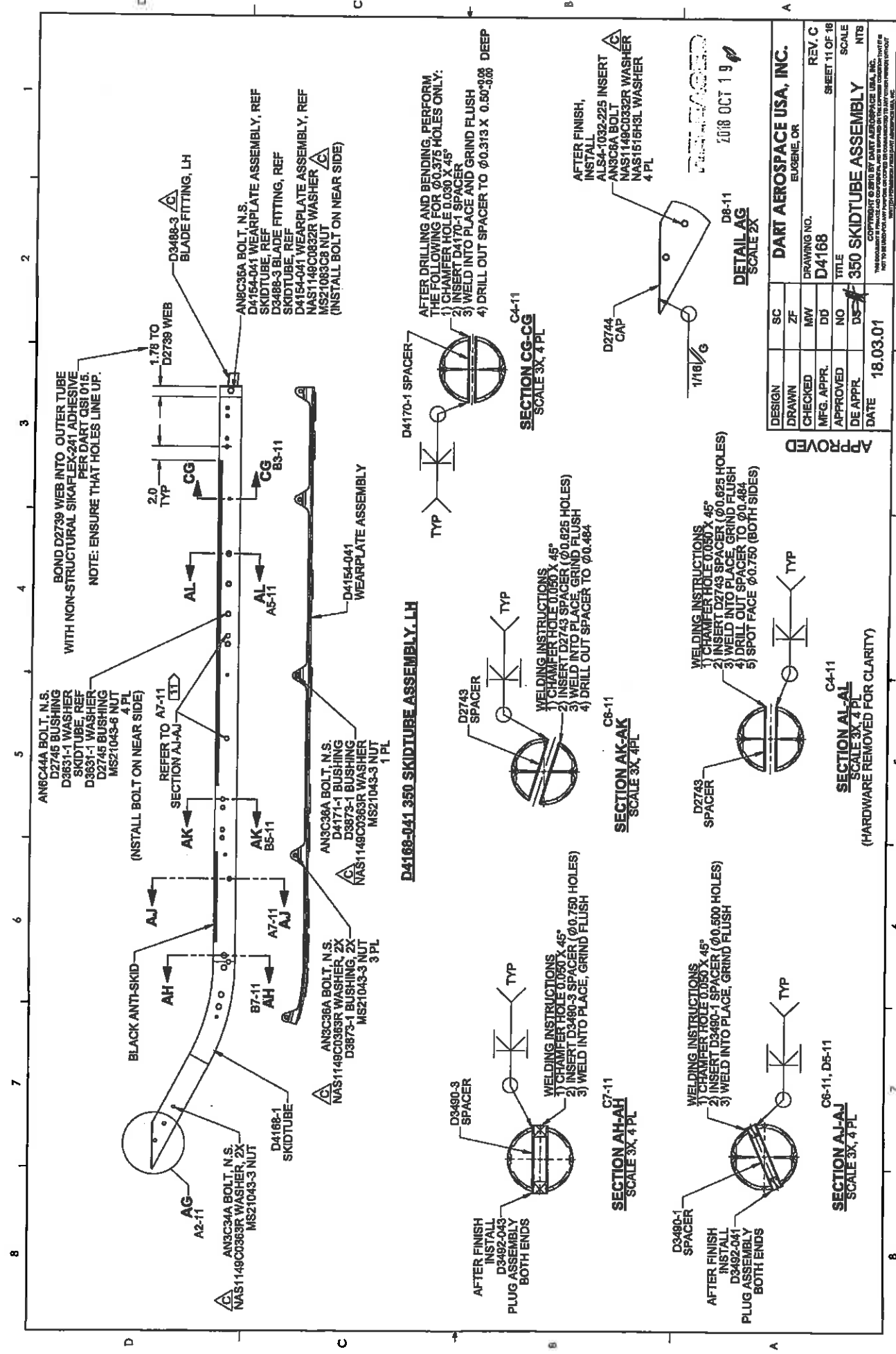
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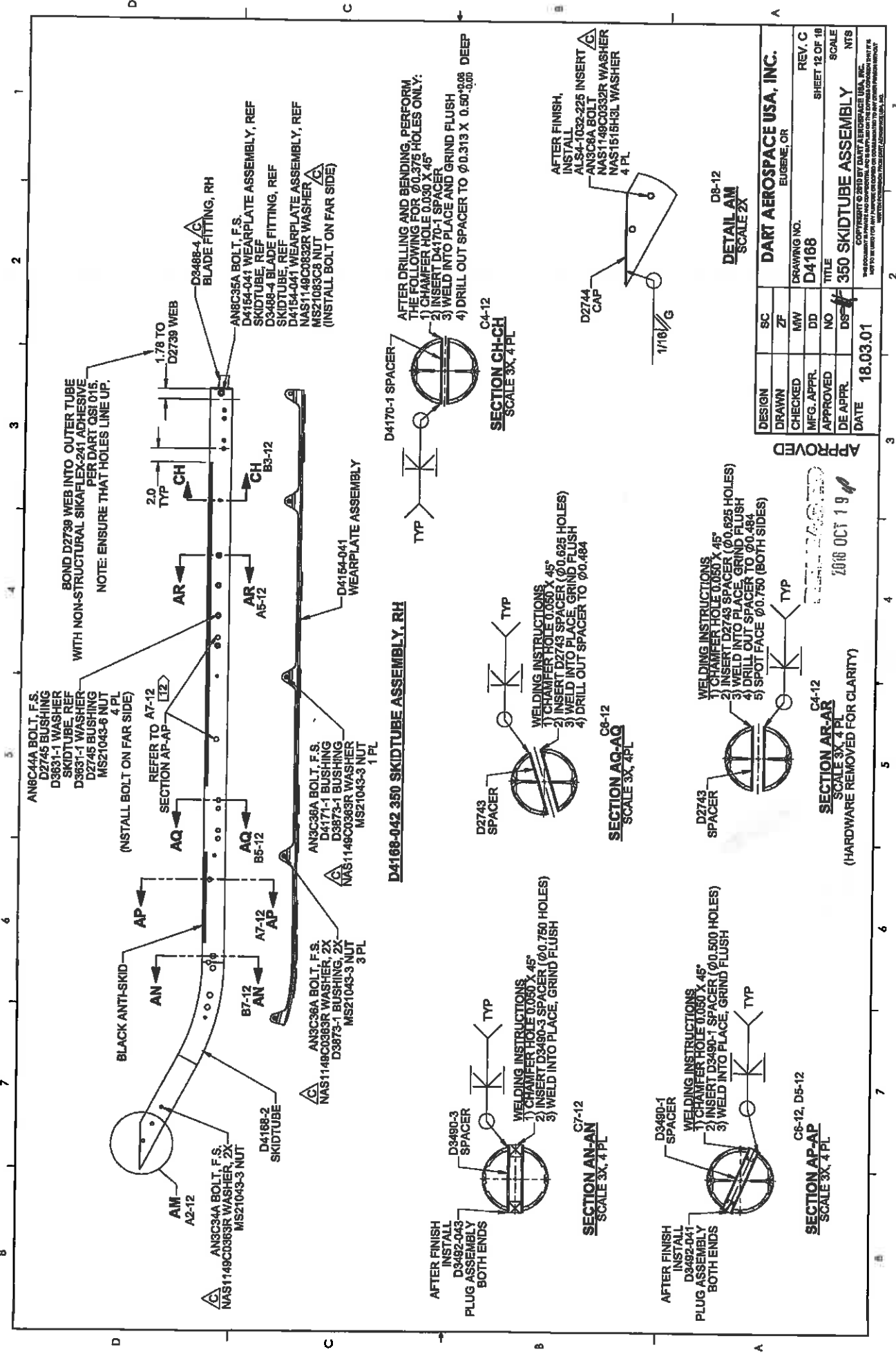
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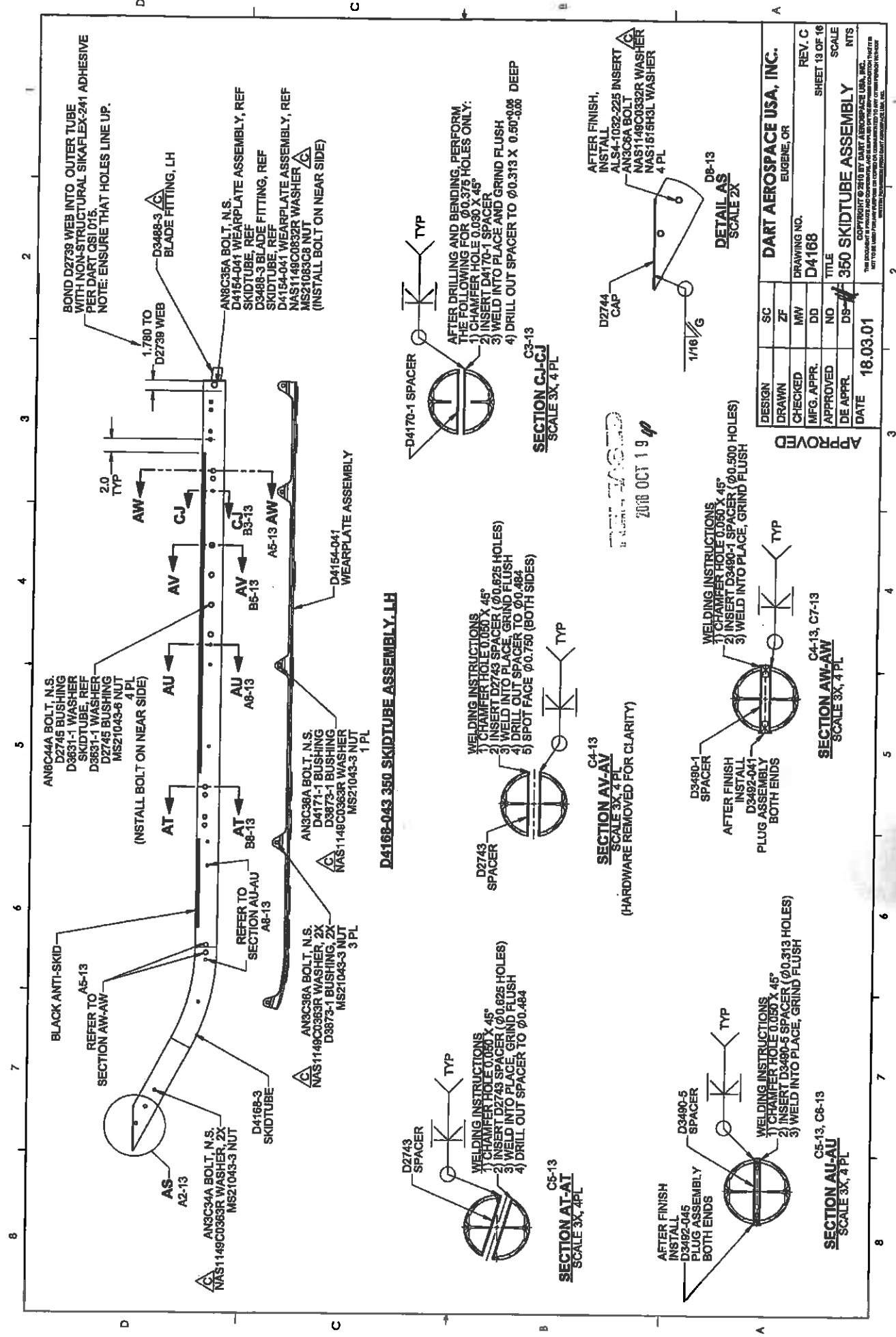


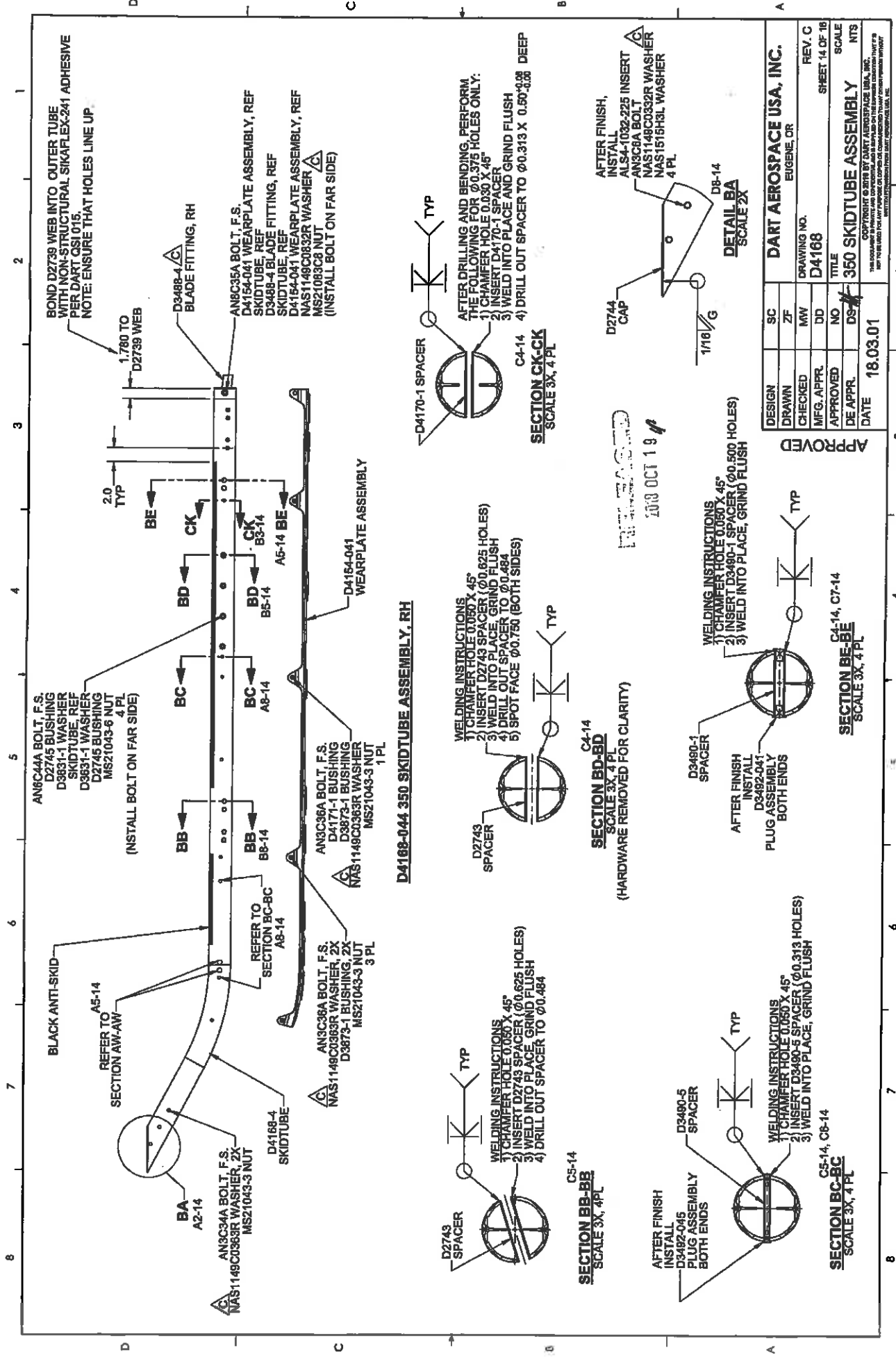
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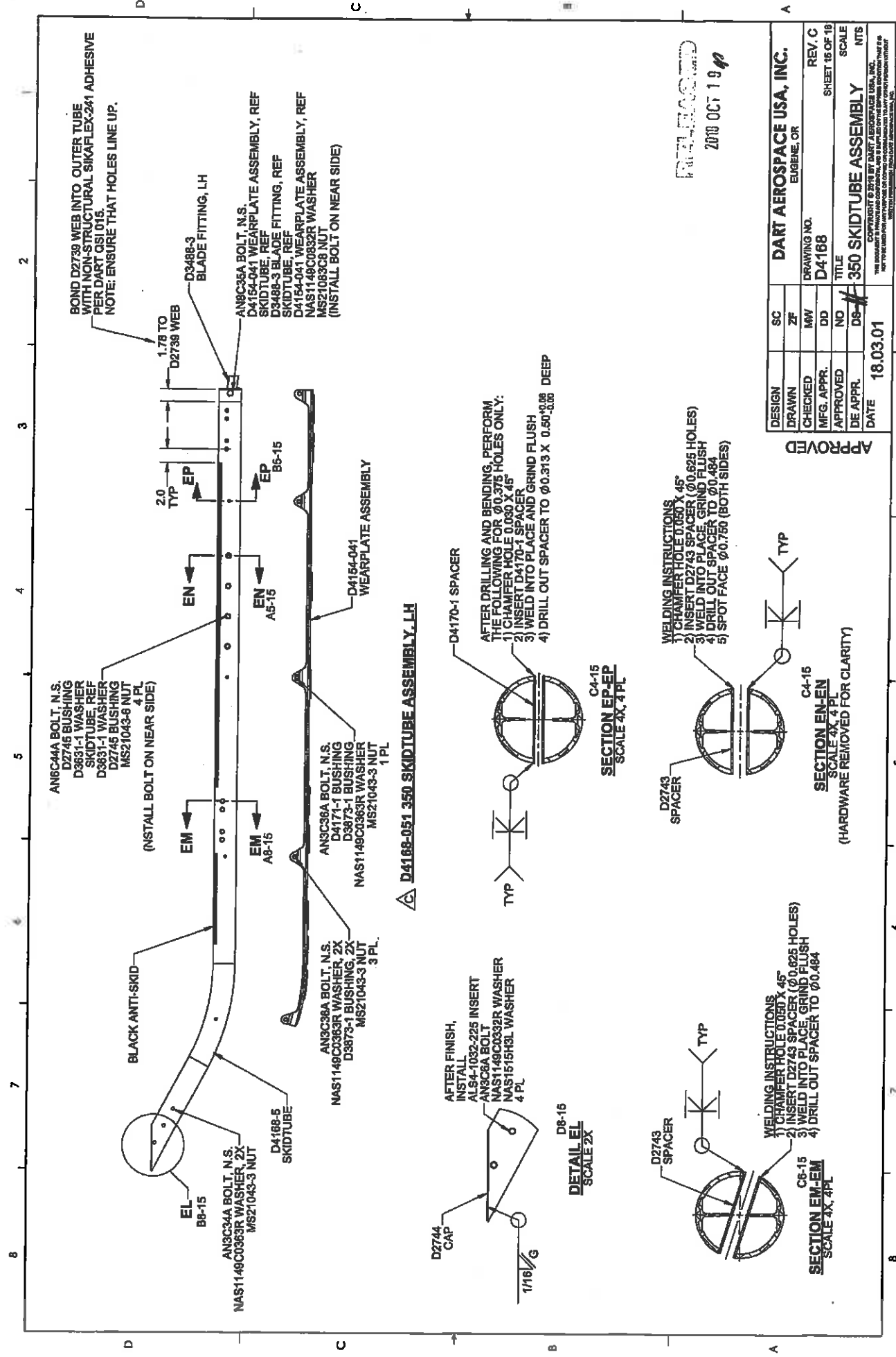
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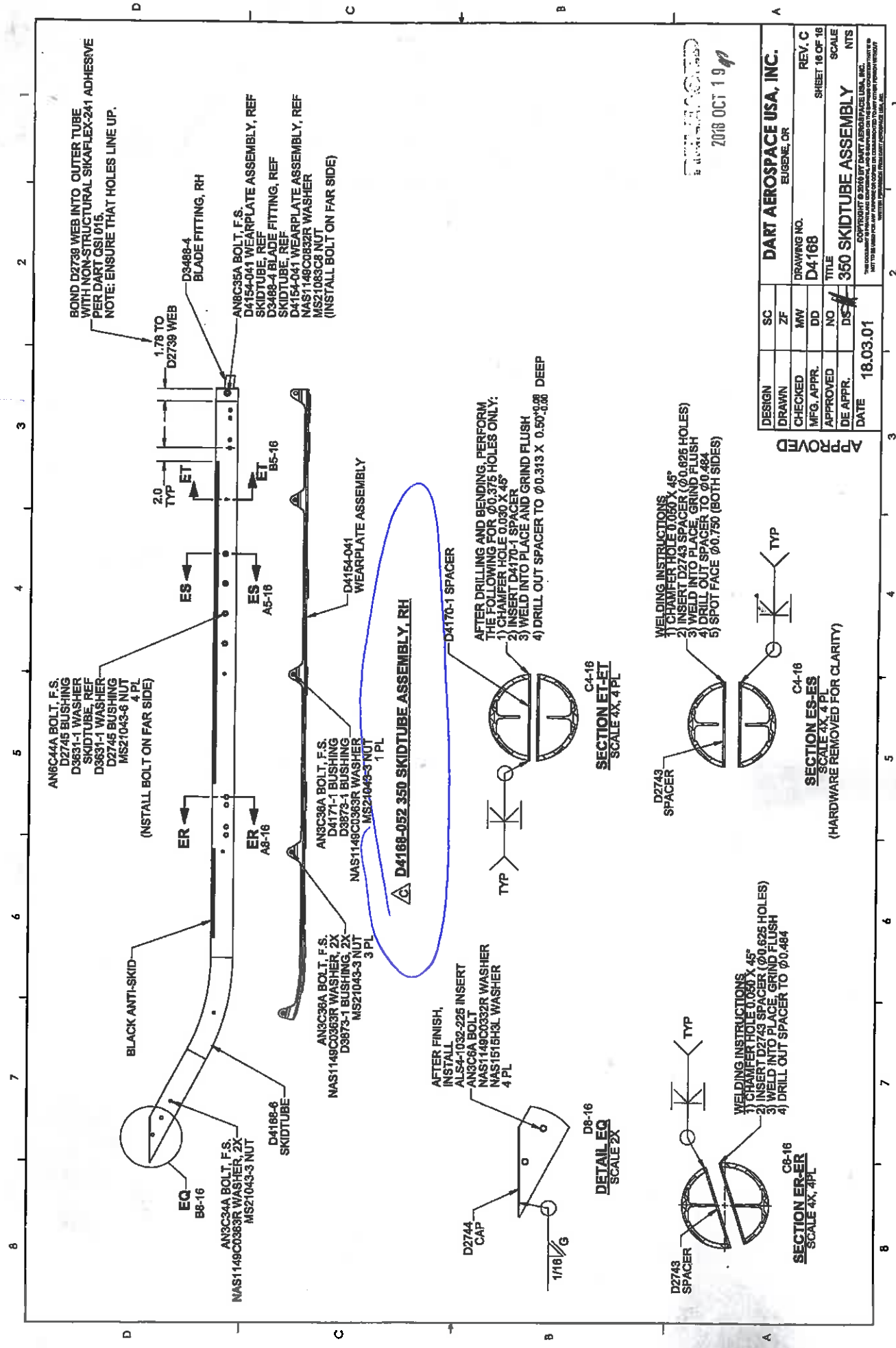




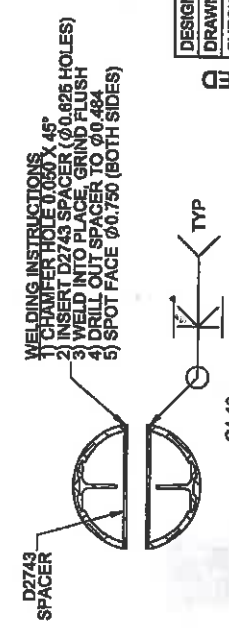




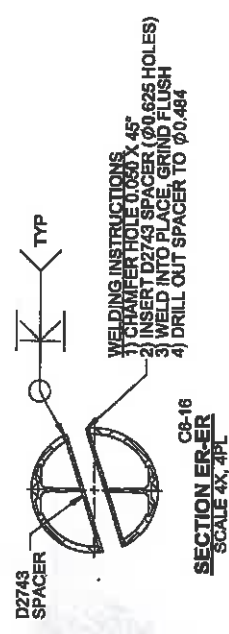




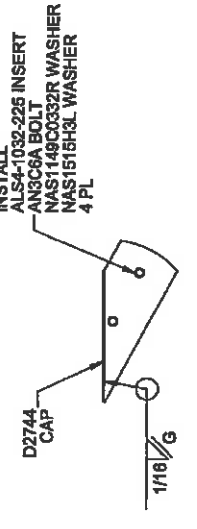
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SCALE 4X, 4 PL



SECTION ES-ES
SCALE 4X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION ER-ER
SCALE 4X, 4 PL



DETAIL EQ
SCALE 2X

Change Record

PAGE 1 OF 1

Part Number: D350-636-023/-024

Description: SKIDTUBE INSTALLATION LH/RH, STD COMPATIBLE W/TRAINING WEARPLATE

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